

~~DUPPLICATE~~

Date: Tuesday, 19/09/2006 8:35:03 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206 L WEB		
Job Number	: 28238			Part Number	: D26547		
Estimate Number	: 10722			Drawing Number	: D2654 REV E1		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 19/09/2006 S.O. No. : N/A			Drawing Revision	: E1		
Prsh't Rev.	: NC			Material	: N/A		
First Issue	: 17/08/2006 Type : LANDING GEAR			Due Date	: 31/08/2006 Qty: 5 Um: Each		
Previous Run	: 27109						
Written By							
Checked & Approved By							
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:e 06.04.05 Added level21			EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:			Description :			
1.0	D26007125			Extrusion 'I Beam' thick			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-7- 125 Web B21130 DT 06-09-19							
2.0	LANDING GEAR 1			LANDING GEAR RESOURCE 1			
Comment: LANDNG GEAR RESOURCE 1 1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends							

3.0	QC5			INSPECT WORK TO CURRENT STEP			
Comment: INSPECT WORK TO CURRENT STEP Pmc 06-09-20(6)							
4.0	HAND FINISHING1			HAND FINISHING RESOURCE #1			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/09/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/09/2006 8:35:03 AM
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Seq. #: Machine Or Operation: Description :

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



PM 06-09-20(5)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 160

BT 06-09-2020

7.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/09/20

Job Completion



U 06/09/20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



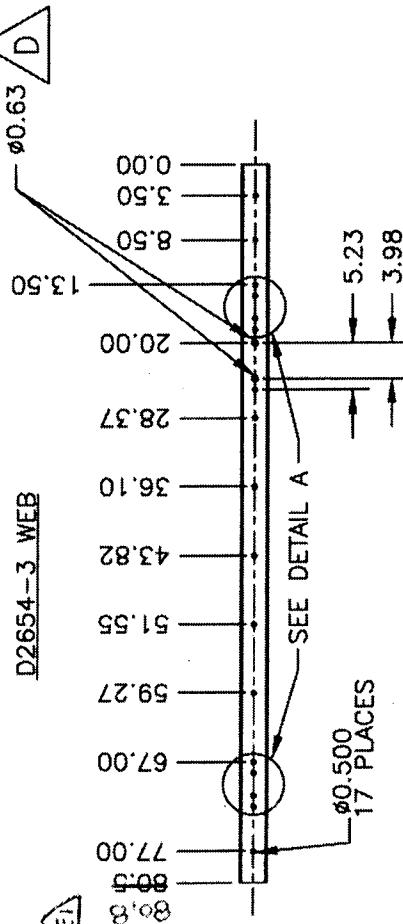
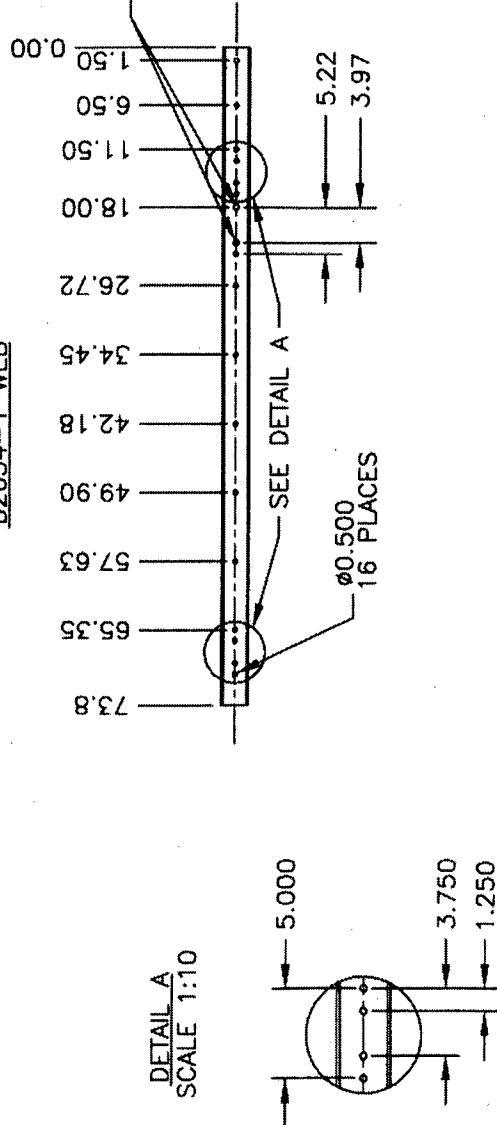
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03150

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2654	SHEET 1 OF 2
DATE	WEB	TITLE	SCALE
04.05.26			1:20

REFERENCE ONLY
RELEASED
04.06.22

A 97.03.25 NEW ISSUE
 B 97.06.26 ALTER HOLE PATRN., 0.500 WAS 0.438
 C 97.10.29 CHANGED HOLE PATTERN
 D 98.01.15 GHW HOLES CHANGED TO Ø0.63
 E 04.05.26 CHANGE LENGTHS, REFORMAT
 E1 04.08.04 PER TOOLING; 80.8 WAS 80.5

D2654-1 WEB



MAKE FROM D2600-5-108 EXTRUSION
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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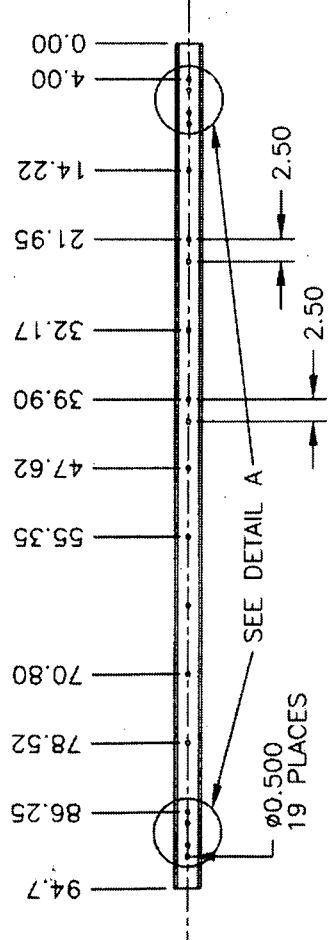
ONE COPY
ISSUED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E
DATE 04.05.26		SHEET 2 OF 2 TITLE WEB SCALE 1:20

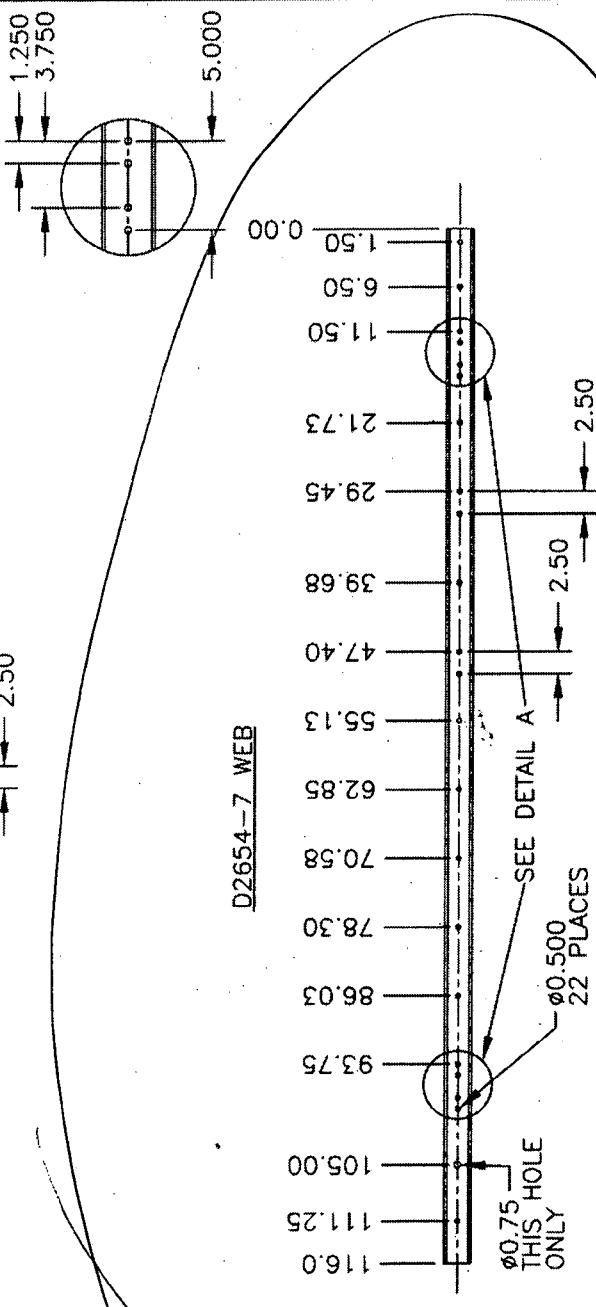
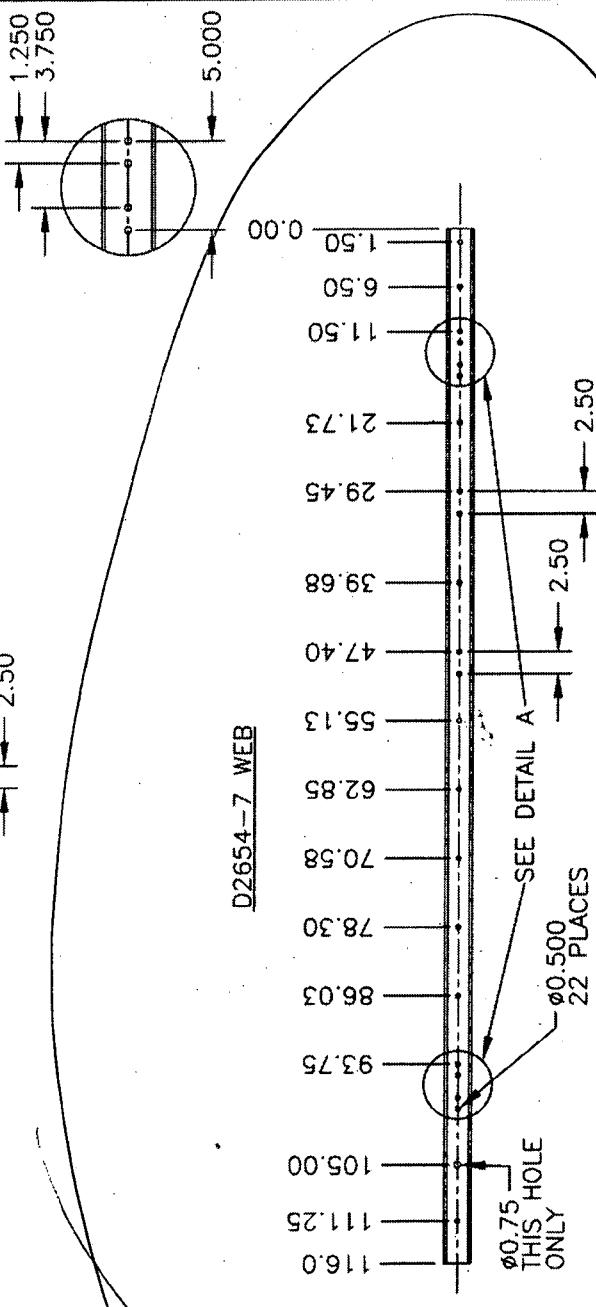
RELEASED
04.05.26

REFERENCE ONLY

D2654-5 WEB



DETAIL A
SCALE 1:10



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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